



Dart Aerospace Ltd.
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D350-636-023
Job Sheet 194170



Part No: D350-636-023

Job Qty: 1 pcs

Part Name: AS350/355 - Skidtubes - Standard w/ Heavy-Duty Wearplates - LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/26/19

Job Tracking No:

Due Date: 4/30/19

Created By: Shannon Hadley

Type: Stock

Description:

Note: D4168-051 REV.C, IIN-D350-636 REV.K IPP REV.A 18.11.29 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	4/30/19		0.00	5.25	Skidtubes - 1 - B4B		BE
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
120	QC 10	1 pcs	4/30/19		0.00	0.00	QC 10 - 10		MAY 03 2019
							QC 10 - 18		
							QC 10 - 24	DAS	
							QC 10 - 43	24	
							QC 10 - 50	9-89	
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	4/30/19		0.00	0.00	QC 5 - 10		DAS MAY 03 2019 68 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		

140 Handfinish - 1-1 Chemical-B4B	1 pcs	4/30/19	0.00 0.99	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/05/06
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	4/30/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	MCG
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	

160 Skidtubes - 2 - B4B	1 pcs	4/30/19	0.00 5.25	Skidtubes - 1 - B4B	00
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MFG
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	RE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 10	1 pcs	4/30/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	DAS
				QC 10 - 58	MAY 15 2019 50
				QC 10 - 9	9-89
180 QC 5	1 pcs	4/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS
				QC 5 - 9	MAY 15 2019 68
				QC 5 - 50	9-89
190 Handfinish - 2-1 Pressure-B4B	1 pcs	4/30/19	0.00 0.99	QC 5 - 30	
				QC 5 - 40	
				Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	MAY 1 6 2019
200 Spray Paint - 2 - B4B	1 pcs	4/30/19	0.00 0.91	Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
				Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	RD 19-5-16
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
				Spray Paint - MJ1 - B4B	
				Spray Paint - MJ2 - B4B	
210 QC 14	1 pcs	4/30/19	0.00 0.00	Spray Paint - MJ3 - B4B	
				Spray Paint - MJ4 - B4B	
				QC 14 - 15	
				QC 14 - 2	HL 14-5-21
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
230 Handfinish - 4-1-Assembly-B4B	1 pcs	4/30/19	0.00 0.99	QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				Handfinish - 4 - 1 - B4B	HL 14-6-20
				Handfinish - 4 - 10 -	

240 QC 5	1 pcs	4/30/19	0.00 0.00	B4B
				Handfinish - 4 - 11 - B4B
				Handfinish - 4 - 12 - B4B
				Handfinish - 4 - 13 - B4B
				Handfinish - 4 - 14 - B4B
				Handfinish - 4 - 15 - B4B
				Handfinish - 4 - 2 - B4B
				Handfinish - 4 - 3 - B4B
				Handfinish - 4 - 4 - B4B
				Handfinish - 4 - 5 - B4B
				Handfinish - 4 - 6 - B4B
				Handfinish - 4 - 7 - B4B
				Handfinish - 4 - 8 - B4B
				Handfinish - 4 - 9 - B4B
				QC 5 - 10
				QC 5 - 12
				QC 5 - 17
				QC 5 - 18
				QC 5 - 19
				QC 5 - 22
				QC 5 - 24
				QC 5 - 3
				QC 5 - 43
				QC 5 - 49
				QC 5 - 51
				QC 5 - 58
				QC 5 - 68
				QC 5 - 9
				QC 5 - 50
				QC 5 - 30
				QC 5 - 40
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	4/30/19	0.00 0.00	Packaging 1 - 1 - B4B
				Packaging 1 - 2 - B4B
				Packaging 1 - 3 - B4B
				Packaging 1 - 4 - B4B
				Packaging 1 - 5 - B4B
				Packaging 1 - 6 - B4B
				Packaging 1 - 7 - B4B
				Packaging 1 - 8 - B4B
				Packaging 1 - 9 - B4B
				Packaging 1 - 10 - B4B
				Packaging 1 - 11 - B4B
				Packaging 1 - 12 - B4B
				Packaging 1 - 13 - B4B
				Packaging 1 - 14 - B4B
				Packaging 1 - 15 - B4B
				Packaging 1 - 16 - B4B
				Packaging 1 - 17 - B4B
				Packaging 1 - 18 - B4B
				Packaging 1 - 19 - B4B
				Packaging 1 - 20 - B4B
				Packaging 1 - 21 - B4B
				Packaging 1 - 22 - B4B
				Packaging 1 - 23 - B4B
				Packaging 1 - 24 - B4B

DASDAS

81 68

9-89 9-89

JUN 26 2019

DAS

28

9-89

280 QC 21 - FG	4/30/19	1	pcs	0.00 0.00	QC 21 - FG - 70	JUL 1 1 2019
275 DC - 1 - B4B	4/30/19	1	pcs	0.00 0.00	QC 21 - FG - 21	JUL 1 1 2019
					DC - 2 - B4B	JUL 1 1 2019
					DC - 1 - B4B	JUL 1 1 2019
					Packaging 3 - 36 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 11 - B4B	JUL 1 1 2019
					Packaging 3 - 10 - B4B	JUL 1 1 2019
					Packaging 3 - 9 - B4B	JUL 1 1 2019
					Packaging 3 - 8 - B4B	JUL 1 1 2019
					Packaging 3 - 7 - B4B	JUL 1 1 2019
					Packaging 3 - 6 - B4B	JUL 1 1 2019
					Packaging 3 - 5 - B4B	JUL 1 1 2019
					Packaging 3 - 4 - B4B	JUL 1 1 2019
					Packaging 3 - 3 - B4B	JUL 1 1 2019
					Packaging 3 - 2 - B4B	JUL 1 1 2019
					Packaging 3 - 1 - B4B	JUL 1 1 2019
270 Packaging 3-1 - Stock - B4B	4/30/19	1	pcs	0.00 0.00	QC 4 - 68	JUL 1 1 2019
					QC 4 - 46	JUL 1 1 2019
					QC 4 - 9	JUL 1 1 2019
					QC 4 - 69	JUL 1 1 2019
					QC 4 - 58	JUL 1 1 2019
					QC 4 - 28	JUL 1 1 2019
260 QC 4	4/30/19	1	pcs	0.00 0.00	Packaging 1 - 36 - B4B	JUL 1 1 2019
					Packaging 1 - 35 - B4B	JUL 1 1 2019
					Packaging 1 - 34 - B4B	JUL 1 1 2019
					Packaging 1 - 33 - B4B	JUL 1 1 2019
					Packaging 1 - 32 - B4B	JUL 1 1 2019
					Packaging 1 - 31 - B4B	JUL 1 1 2019
					Packaging 1 - 30 - B4B	JUL 1 1 2019
					Packaging 1 - 29 - B4B	JUL 1 1 2019
					Packaging 1 - 28 - B4B	JUL 1 1 2019
					Packaging 1 - 27 - B4B	JUL 1 1 2019
					Packaging 1 - 26 - B4B	JUL 1 1 2019
					Packaging 1 - 25 - B4B	JUL 1 1 2019

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
Descriptions: D4168-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill
then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER
POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168
sheet 4 (D4168-5 details). Drill using drill jig DT8150 & DT8863A for first side only DT8863B for second side 4- Locate
DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section DE-DE. Open to 0.500" using hole saw.
VERIFY AND RECORD FWD BEND ANGLE. 5- Drill tow ring hole using DT9616 detail "DA" 6- Drill most FWD wearplate
hole using DT9678 locating off of 66.54" hole. 7- Open up holes of Detail DA to 0.297" (total of 2 holes per side) and .201"
(total of 1 hole per side using DT9616) 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from
bending as per QSI 004 A/R Aluminum Rod batch: 139011 9- Grind welds flush as per Dwg D4168
120 - (QC10- Inspect visual per QSI004- ground welds)
130 - (QC5- Inspect part completeness to step on W/O)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (QC7-Inspect Chemical Conversion Coat)
160 - 1-Open up holes using hole saw of Detail DB and ground handling section EN-EN to 0.625" (total of 8 holes per
side) as per dwg D4168. Open wearplate holes to size as per dwg (4 holes per sides), section EP-EP 4-Chamber holes of
Detail DB, ground handling section AL-AL per dwg D4168 (welding instructions on sheet 8) 5-Deburr and blow out all
chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI
015, let cure for 12hrs. A/R Sikaflex-291 batch: 57430 exp. date: 08/2015 8- Weld spacers D2743 as per dwg D4170-1 & QSI004 (welding instructions on
sheet) A/R Aluminum Rod batch: 139011 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling
holes section (total of 4 places per side) as per dwg D4168, section EN-EN 12-C'bore section CG-CG. ADJUST
TOOLING AS REQUIRED. VERF BY: 13- Deburr holes, ensure tube is free of all scratches before
sending to paint. *****
170 - QC10- Inspect visual per QSI004- ground welds)
180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do
not acid etch.
200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349
BATCH: 515577 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5179047
210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
230 - (Assemble as per dwg) 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting
D3488-3, wearshoes and ground handling hardware as per dwg D4168 SIKAFLEX 241 BATCH: 5174342-EXP
DATE: 13-12-8 5-Coat all exposed fasteners with "LPS Procyon" batch:
240 - (QC5- Inspect part completeness to step on W/O)
250 - (Pick Kit) If making a D350-636-215 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A
260 - QC4- 100% Inspect kits for completeness)*****ensure antiseize is on AN8C21A bolts*****
270 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPPD350-636-023 Location
FG071
275 - record twd angle: 89.9°
280 - (QC21- Final Inspection - Work Order Release)
Photocopy blue file and type labels per PPP D350-636-023 CHG 001

Part / Item	Component Name	Quantity	Operation	Job BOM	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	110-Skidtubes - 1	5166439	009896
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5160371	
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5176881	
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	5156381	
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B	5152643	
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
D2745	Bushing	8 pcs (8 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
D3873-1	Washer	8 pcs (8 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
D4154-041	Wearplate Assembly	7 pcs (7 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
D4170-1	Bushing	4 pcs (4 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
D4171-1	Bushing	1 pcs (1 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
MS21043-3	Nut	5 Ea (5 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
MS21043-6	Nut	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
MS21083C8	Nut	1 Ea (1 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
NAS1149C0332R	Washer	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
NAS1149C0363R	Washer	9 Ea (9 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
NAS1149C0832R	Washer	1 Ea (1 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B	5152649	
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	516967	
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	516967	
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5159549	
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5164203	
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166718	
110-Skidtubes - 1					
160-Skidtubes - 2 - B4B					
230-Handfnish - 4-1-Assembly-B4B					
250-Packaging 1-1 - Pick Kit - B4B					
Component Part					
Required					
Inventory					
Allocated					

Job Allocations

Part / Item	Component Name	Quantity	Operation
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	110-Skidubes - 1
D2744	Cap	1 pcs (1 ea)	110-Skidubes - 1
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidubes - 2 - B4B
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidubes - 2 - B4B
AL54-1032-225	Rivnut	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfnish - 4-1-Assembly-B4B
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfnish - 4-1-Assembly-B4B
D2745	Bushing	8 pcs (8 ea)	230-Handfnish - 4-1-Assembly-B4B
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfnish - 4-1-Assembly-B4B
D3631-1	Washer	8 pcs (8 ea)	230-Handfnish - 4-1-Assembly-B4B
D3873-1	Bushing	7 pcs (7 ea)	230-Handfnish - 4-1-Assembly-B4B
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfnish - 4-1-Assembly-B4B
D4170-1	Bushing	4 pcs (4 ea)	230-Handfnish - 4-1-Assembly-B4B
D4171-1	Bushing	1 pcs (1 ea)	230-Handfnish - 4-1-Assembly-B4B
MS21043-3	Nut	5 Ea (5 ea)	230-Handfnish - 4-1-Assembly-B4B
MS21043-6	Nut	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B
MS21083C8	Nut	1 Ea (1 ea)	230-Handfnish - 4-1-Assembly-B4B
NAS1149C0332R	Washer	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B
NAS1149C0363R	Washer	9 Ea (9 ea)	230-Handfnish - 4-1-Assembly-B4B
NAS1149C0832R	Washer	1 Ea (1 ea)	230-Handfnish - 4-1-Assembly-B4B
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfnish - 4-1-Assembly-B4B
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B

009896	Container
5166439	
5160371	
5176881	
5156381	
5152643	
5152649	
FM11370741	
5049487	
5167316/K31	
5160325	
5163736	
5179042	
518118	
517267	
X 5191509	
- 5137508	
5142731	
5094569	
5149193	
5163203	
5140669	
5136100	
5076017-2	
5083559	
516967	
516967	
5159549	
5164203	
5166718	

Job BOM

Part Specifications	Specifications could not be found.
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RELEASED
2018 OCT 19

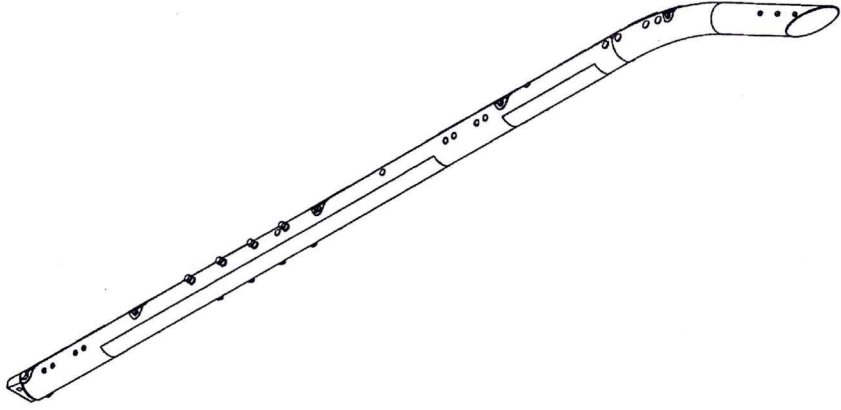
APPROVED

DESIGN	SC
DRAWN	ZF
CHECKED	MW
MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS

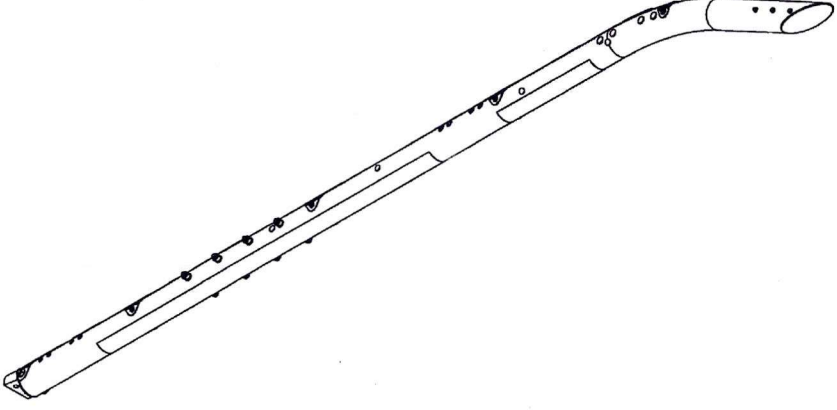
DATE 18.03.01

DART AEROSPACE USA, INC.	DART AEROSPACE USA, INC.
EUGENE, OR	EUGENE, OR
DRAWING NO. D4168	DRAWING NO. D4168
REV. C	REV. C
SHEET 2 OF 16	SHEET 2 OF 16
SCALE	SCALE
350 SKIDTUBE ASSEMBLY	350 SKIDTUBE ASSEMBLY
NTS	NTS

D4168-041 350 SKIDTUBE ASSEMBLY, LH



D4168-042 350 SKIDTUBE ASSEMBLY, RH



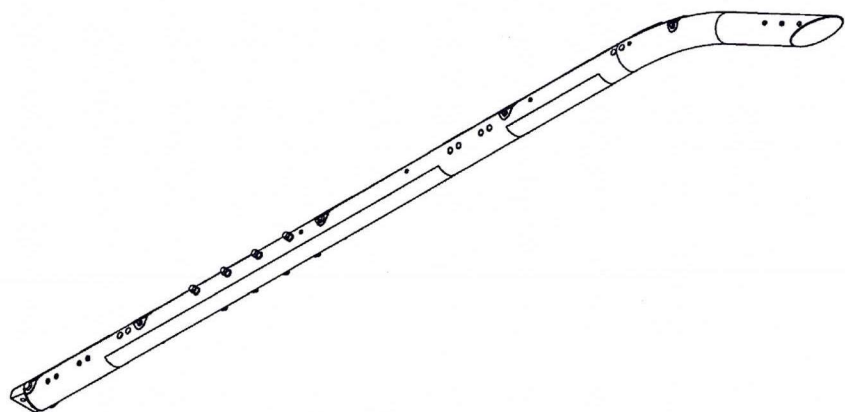
RELEASED
2018 OCT 19

APPROVED

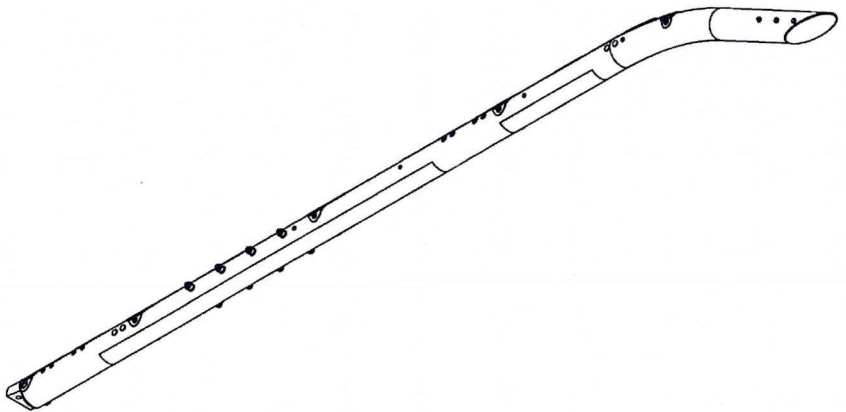
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CHECKED	MW
MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS
DATE	18.03.01

DART AEROSPACE USA, INC.	DART AEROSPACE USA, INC.
EUGENE, OR	EUGENE, OR
DRAWING NO.	D4168
REV. C	REV. C
SHEET 3 OF 16	SHEET 3 OF 16
SCALE	SCALE
NTS	NTS
350 SKIDTUBE ASSEMBLY	350 SKIDTUBE ASSEMBLY
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THIS DOCUMENT IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE	THIS DOCUMENT IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE

D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH



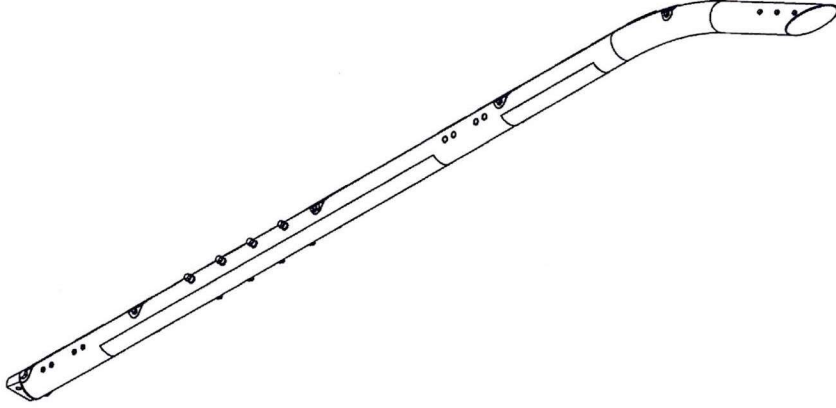
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2019 OCT 19

APPROVED

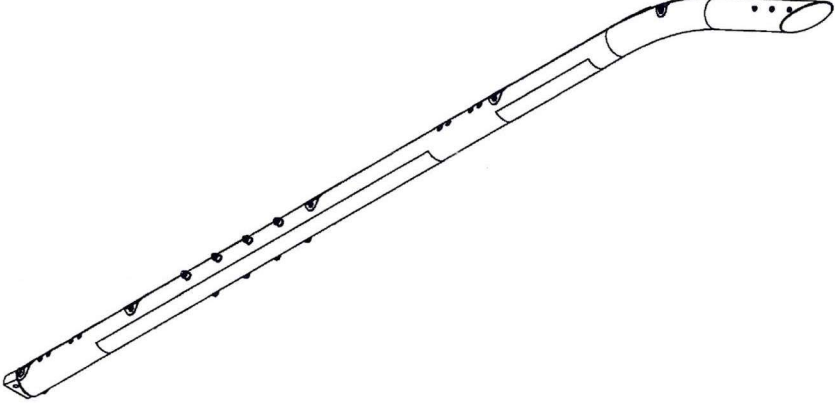
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APPROVED	NO
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DATE	18.03.01

DART AEROSPACE USA, INC.	DRAWING NO.
EUGENE, OR	D4168
REV. C	SHEET 4 OF 16
SCALE	350 SKIDTUBE ASSEMBLY
NTS	COPYRIGHT © 2018 BY DART AEROSPACE USA, INC.
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D4168-051 350 SKIDTUBE ASSEMBLY, LH



D4168-052 350 SKIDTUBE ASSEMBLY, RH

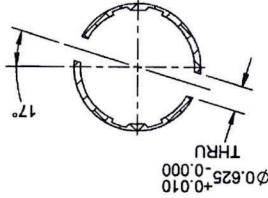


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DE APPR.					
TITLE		350 SKIDTUBE ASSEMBLY			
SCALE		NTS			
SHEET 5 OF 16		REV. C			
DART AEROSPACE USA, INC.		DRAWING NO. D4168			
EUGENE, OR		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.			
		NOT BE USED FOR REPAIR OR CONVERSION TO ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

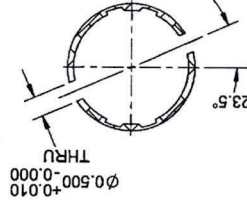
APPROVED

RELEASED
2010 OCT 19

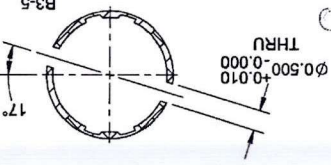
SECTION G-G
SCALE 4X, 4 PL



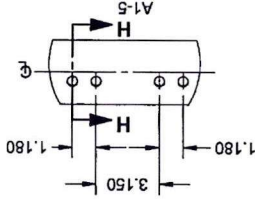
SECTION E-E
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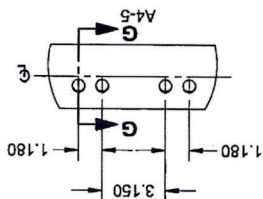
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SCALE 4X, 4 PL



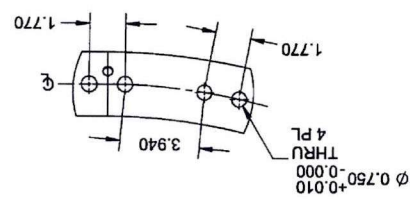
DETAIL D
SCALE 2X



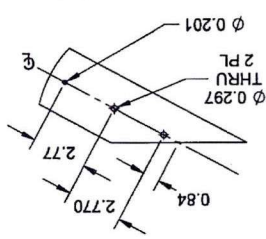
DETAIL C
SCALE 2X



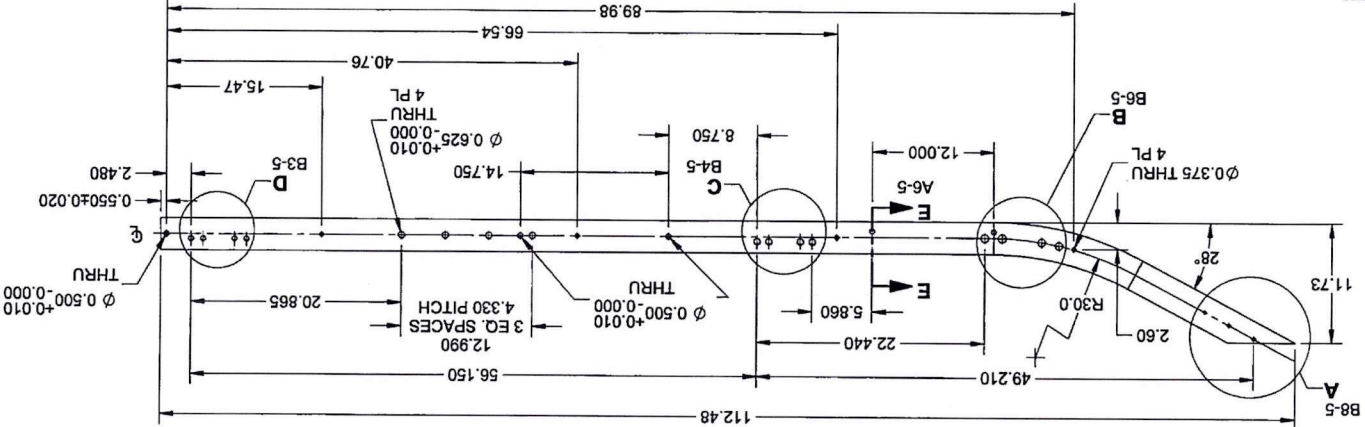
DETAIL B
SCALE 2X



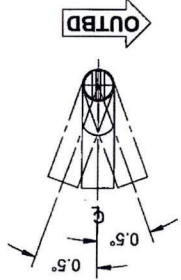
DETAIL A
SCALE 2X

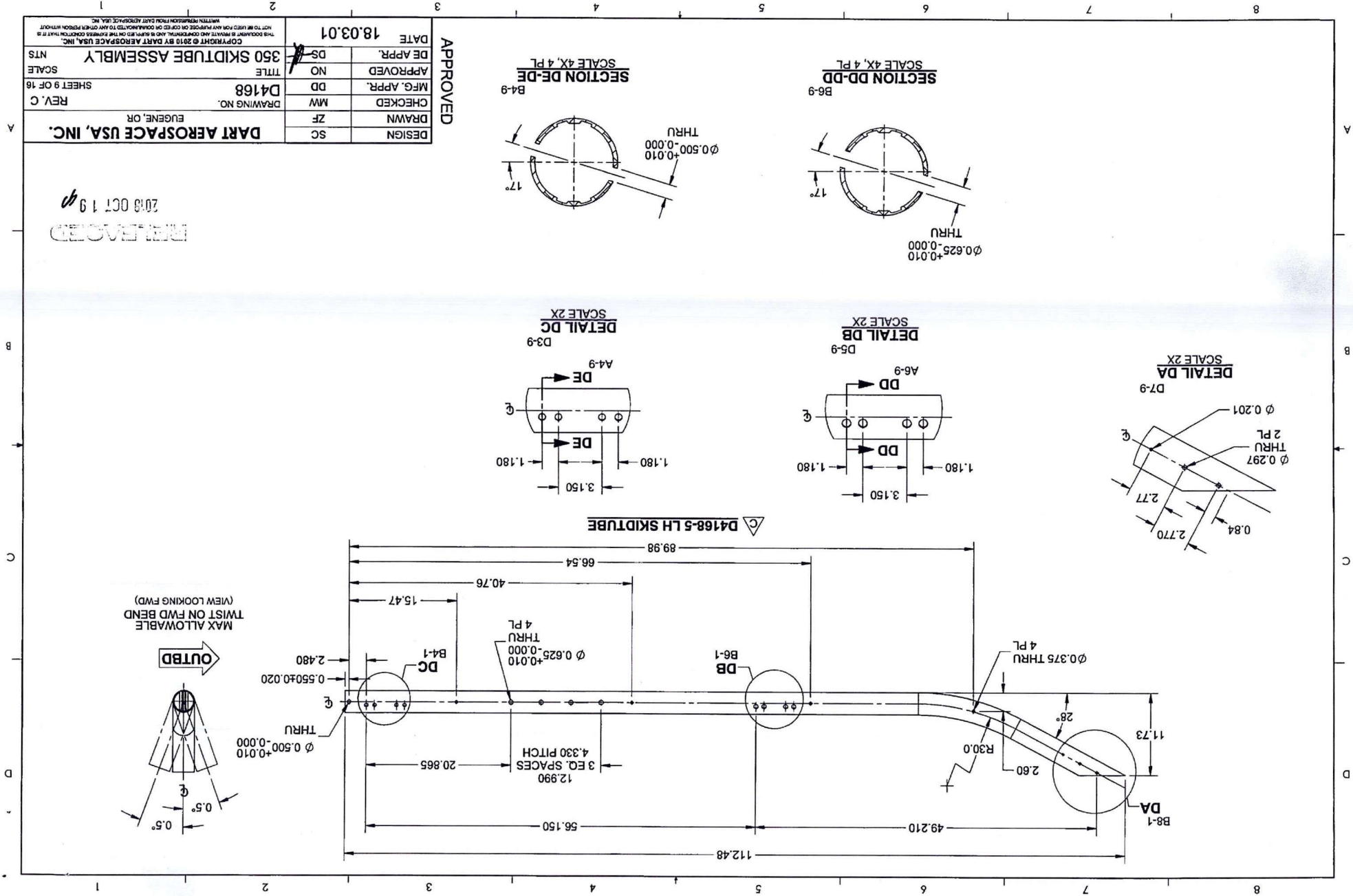


D4168-1 LH SKIDTUBE



MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)

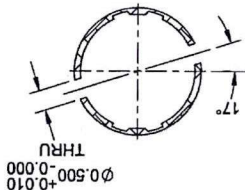




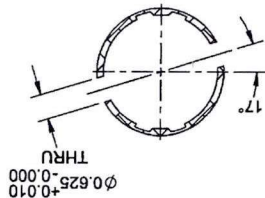
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APPROVED	NO	APPROVED	DD	MFG. APPR.	DD	TITLE	350 SKIDTUBE ASSEMBLY	SCALE	NTS	DATE	18.03.01
DE APPR.	DS	DE APPR.	DS	DE APPR.	DS	DE APPR.	DS	DE APPR.	DS	DE APPR.	DS

APPROVED

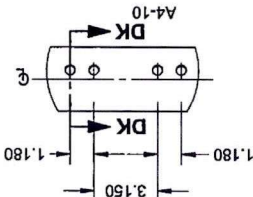
SECTION DK-DK
SCALE 4X, 4 PL
B4-10



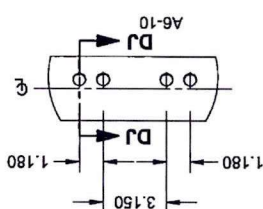
SECTION DJ-DJ
SCALE 4X, 4 PL
B6-10



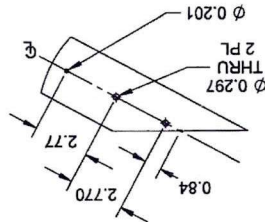
DETAIL DH
SCALE 2X
D3-10



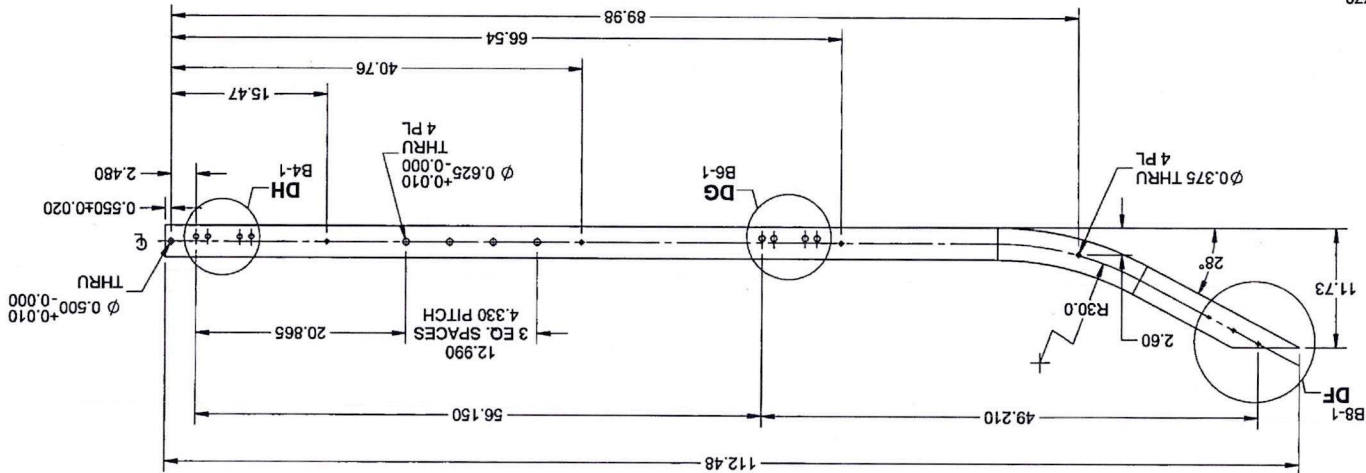
DETAIL DG
SCALE 2X
D5-10



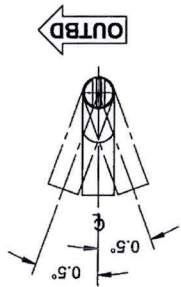
DETAIL DF
SCALE 2X
D7-10



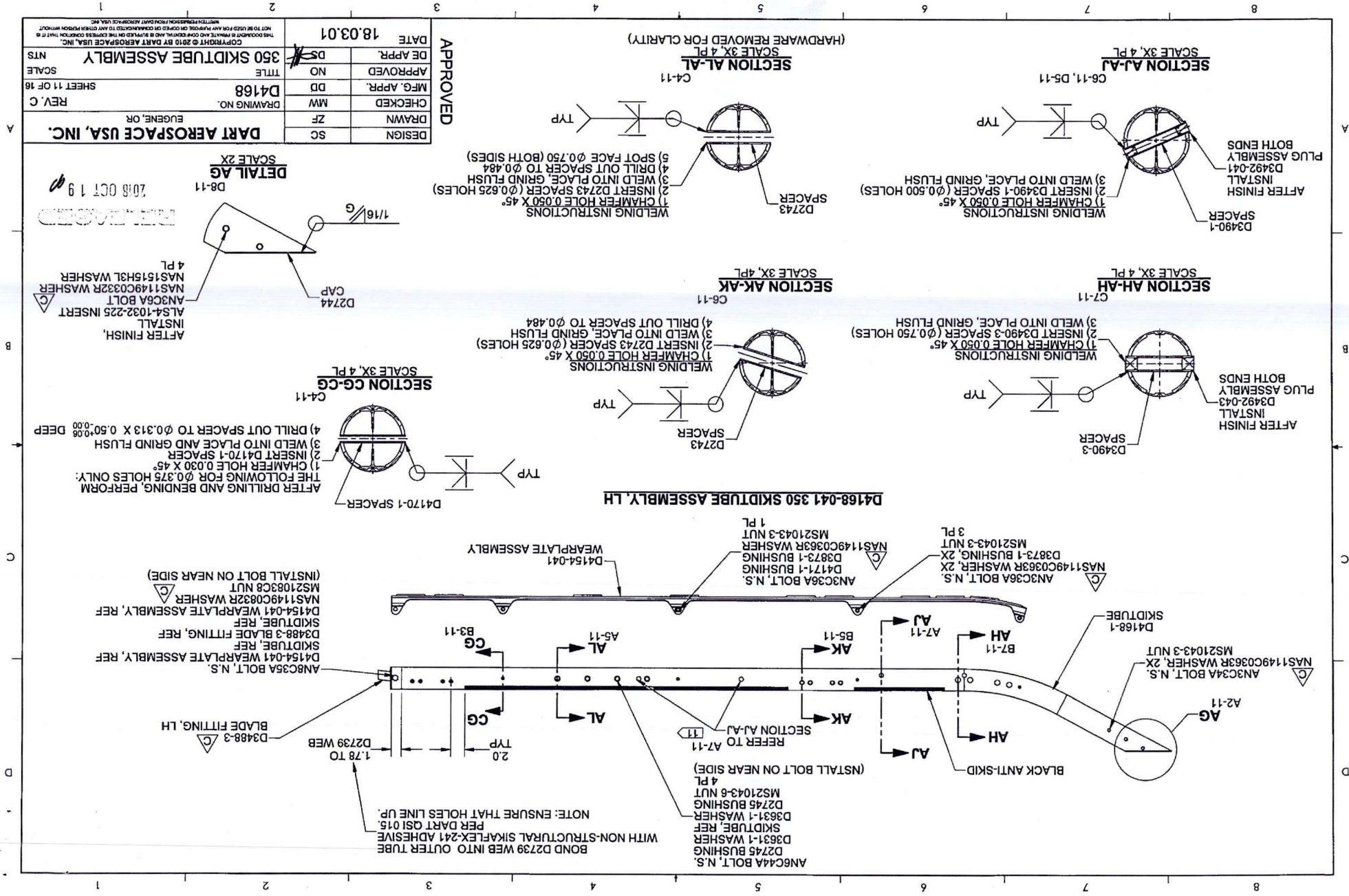
D4168-6 RH SKIDTUBE



MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)

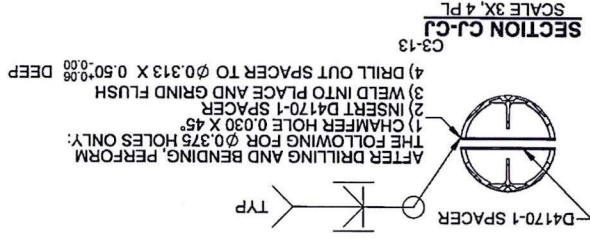
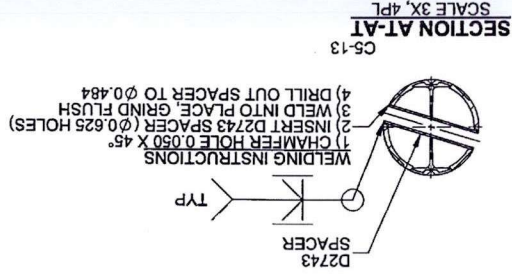
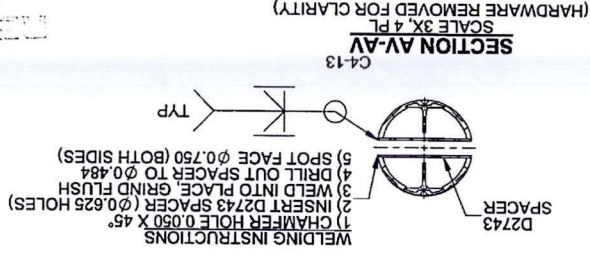
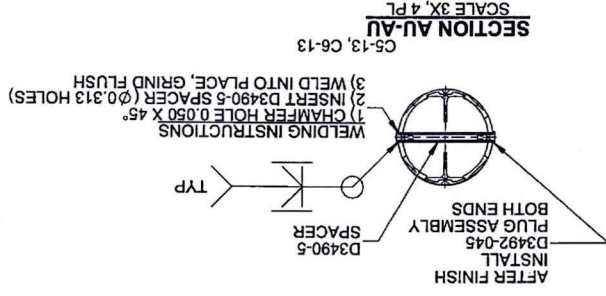
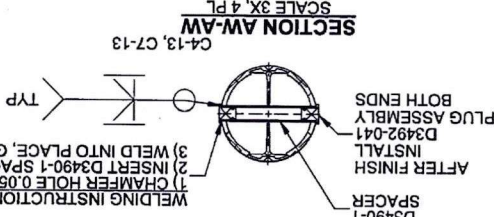


2018 OCT 19
REWORKED

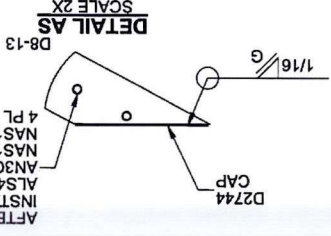
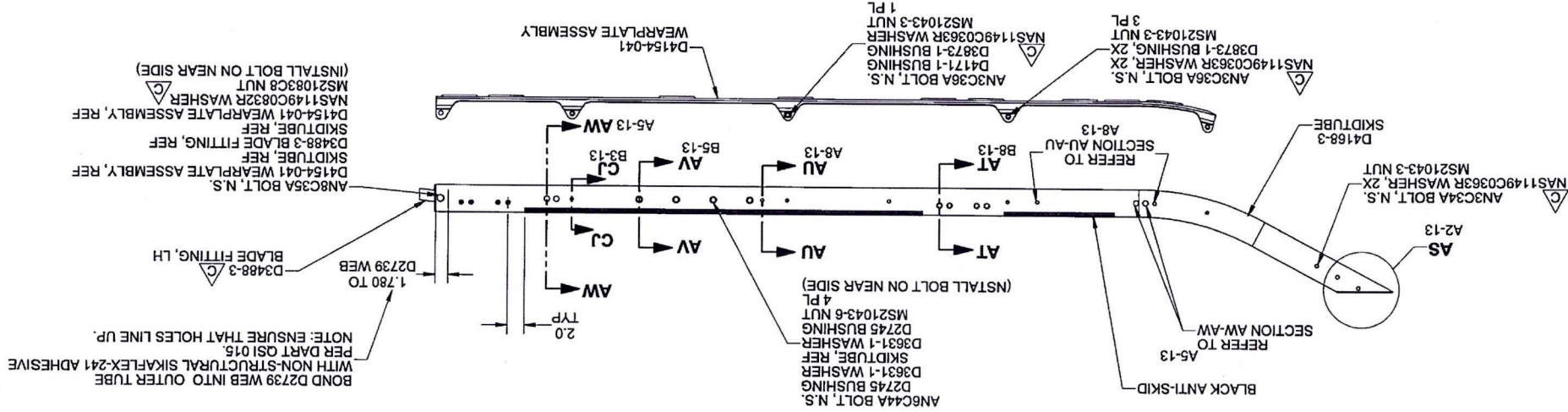


DATE	18.03.01
DESIGN	SC
DRAWN	ZF
CHECKED	MM
APPROVED	DD
DE APPR.	DS
TITLE	350 SKIDTUBE ASSEMBLY
SCALE	NTS
REV. C	
DRAWING NO.	D4168
DART AEROSPACE USA, INC.	EUGENE, OR

APPROVED



D4168-043 350 SKIDTUBE ASSEMBLY, LH



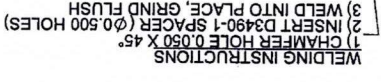
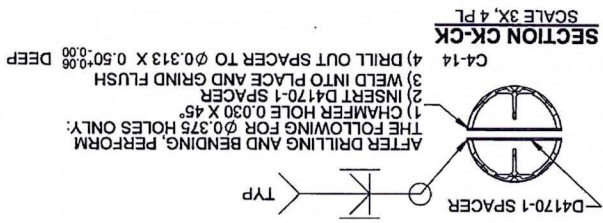
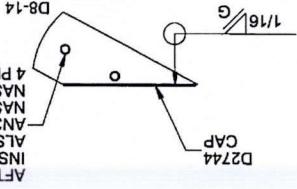
2018 OCT 19

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DRAWING NO.	D4168		
REV. C			
SHEET 14 OF 16			
SCALE			
NTS			

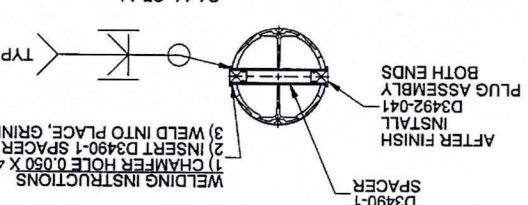
DART AEROSPACE USA, INC.

EUGENE, OR

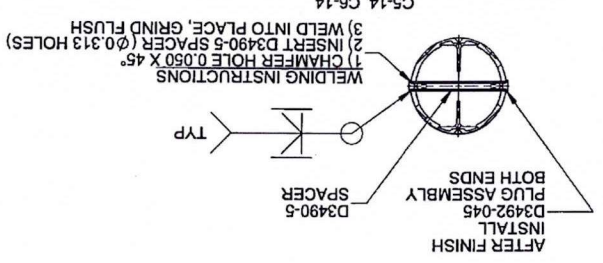
DETAIL BA



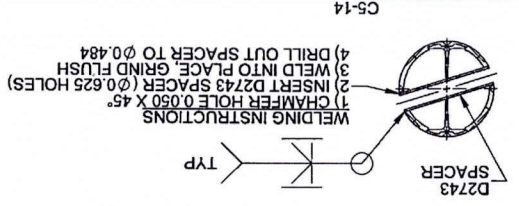
SECTION BE-BE



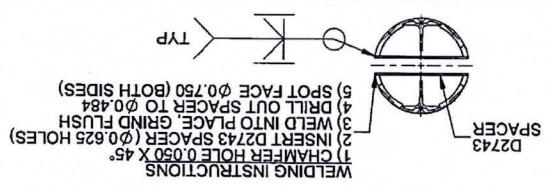
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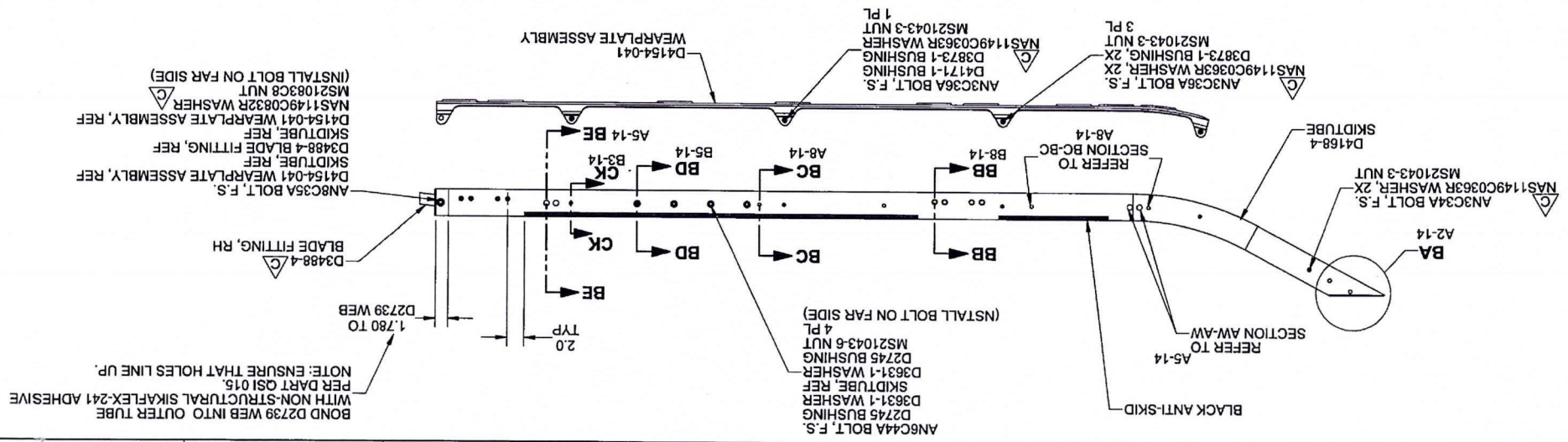
SECTION BB-BB



SECTION BD-BD



D4168-044 350 SKIDTUBE ASSEMBLY, RH



BOND D2739 WEB INTO OUTER TUBE
PER DART QSI 015
NOTE: ENSURE THAT HOLES LINE UP.

WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE

BLADE FITTING, RH

D3488-4

AN8C36A BOLT, F.S.

D4154-041 WEARPLATE ASSEMBLY, REF

SKIDTUBE, REF

D3488-4 BLADE FITTING, REF

D4154-041 WEARPLATE ASSEMBLY, REF

SKIDTUBE, REF

MS21083C8 NUT

(INSTALL BOLT ON FAR SIDE)

AN8C36A BOLT, F.S.

D4171-1 BUSHING

D3873-1 BUSHING, 2X

NAS1149C0363R WASHER, 2X

MS21043-3 NUT

3 PL

AN8C36A BOLT, F.S.

D3873-1 BUSHING

NAS1149C0363R WASHER

MS21043-3 NUT

1 PL

WEARPLATE ASSEMBLY

D4154-041

AS-14 BE

BD

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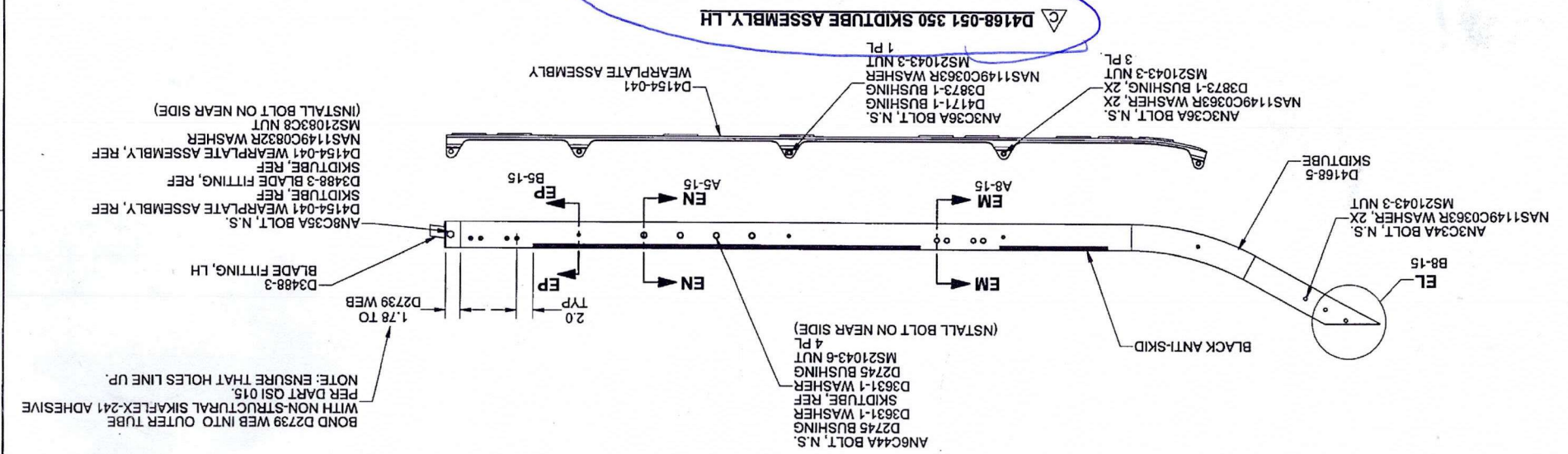
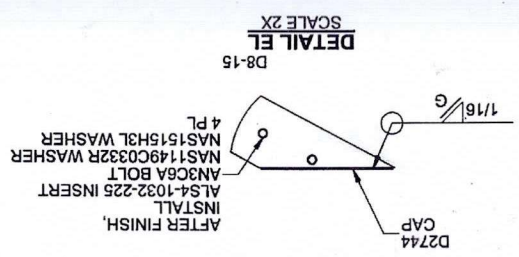
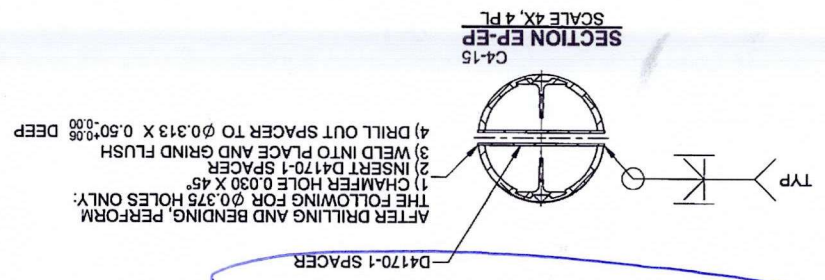
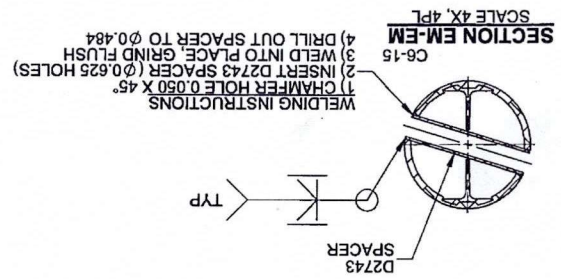
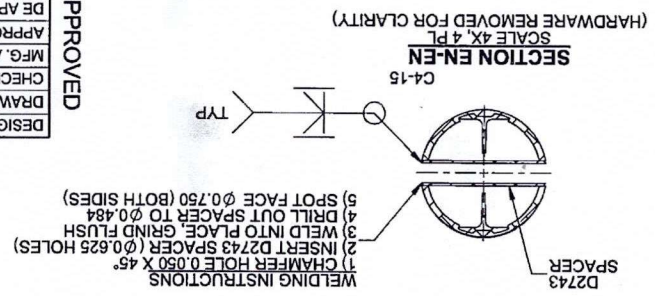
BC

BB

BE

DATE	18.03.01
DESIGN	SC
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MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS
TITLE	350 SKIDTUBE ASSEMBLY
SCALE	NTS
SHEET 15 OF 18	REV. C
DART AEROSPACE USA, INC.	EUGENE, OR

APPROVED



RELEASED
2010 OCT 19

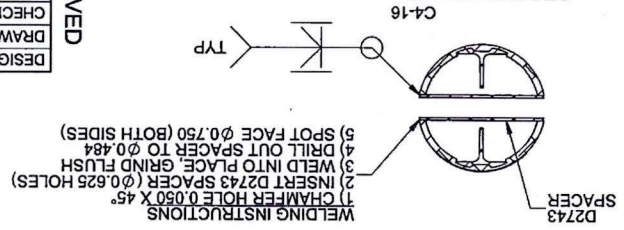
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APPROVED	NO	TITLE	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	SCALE	SHEET 16 OF 16	NTS

DART AEROSPACE USA, INC.
EUGENE, OR

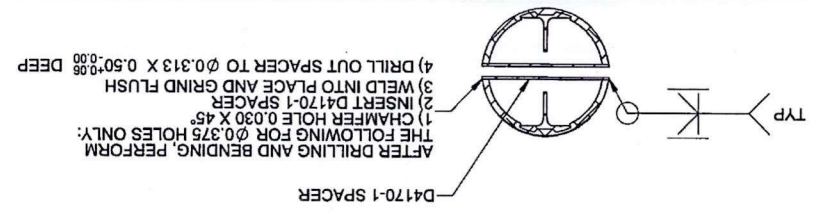
2018 OCT 19
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APPROVED

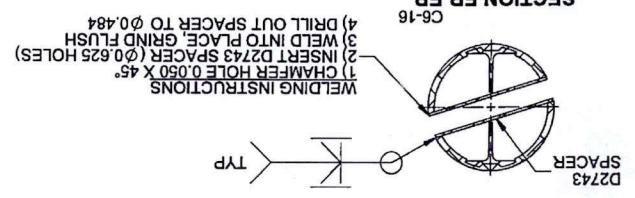
SECTION ES-ES SCALE 4X, 4 PL (HARDWARE REMOVED FOR CLARITY)



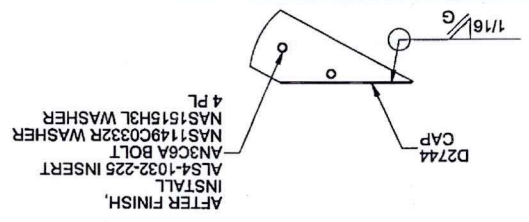
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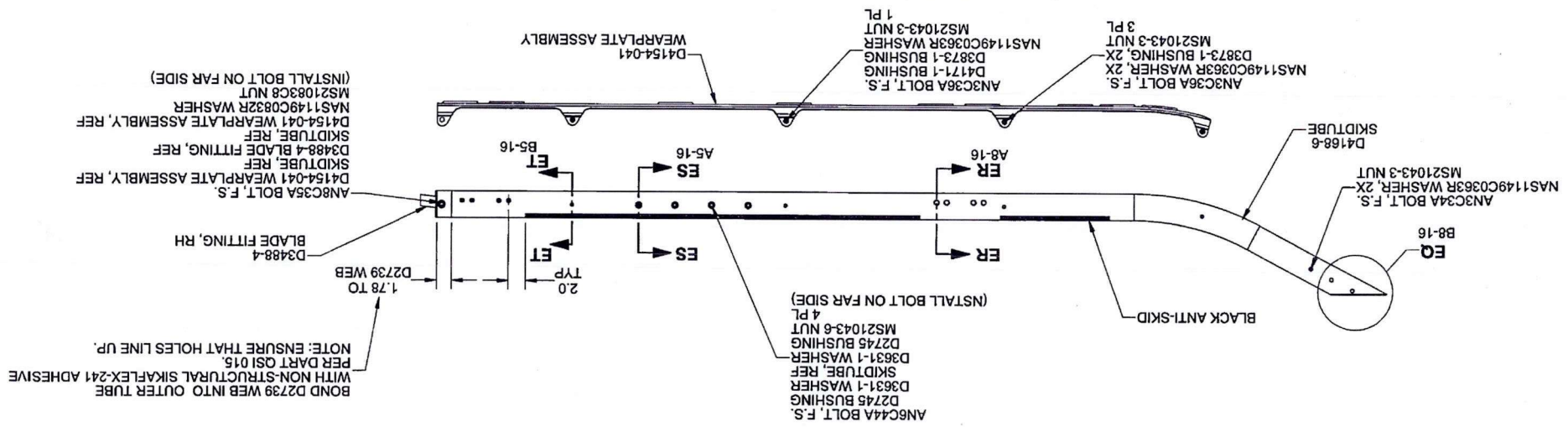
SECTION ER-ER SCALE 4X, 4 PL



DETAIL EQ SCALE 2X



D4168-052 350 SKIDTUBE ASSEMBLY, RH



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Entered:

Date:

NCR No.

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality		Date : _____ Sequence #: _____ QTY Affected : _____		Description Work Order Deviation Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator		Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		Other/Details: ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY	
------------------------------	--	--	--	---	--	---	--	---	--	---	--	--	--	--	--	----------------	--

S177125 L1

Instructions: FAA STC SR00646SE 18/04/12, T1, STC SH99-7 Issue 2, EASA ST

Exp Date:

Inspector:

Revision: C/K

Serial No/Batch: S177125

Job No: 194170

Part: D350-636-023



Container No: S177125

DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty	-015	-016	-017	-018	-023	-024	-047	Part Number	Description
		X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRISE/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRISE/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
						X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
							X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
								X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1								D4168-041	SKIDTUBE ASSEMBLY, LH
1	1								D4168-042	SKIDTUBE ASSEMBLY, RH
1	1								D4168-043	SKIDTUBE ASSEMBLY, LH
1	1								D4168-044	SKIDTUBE ASSEMBLY, RH
1	1								D4168-051	SKIDTUBE ASSEMBLY, LH
1	1								D4168-052	SKIDTUBE ASSEMBLY, RH
1	1								D4168-1	SKIDTUBE WELDMENT, LH
1	1								D4168-2	SKIDTUBE WELDMENT, RH
1	1								D4168-3	SKIDTUBE WELDMENT, LH
1	1								D4168-4	SKIDTUBE WELDMENT, RH
1	1								D4168-5	SKIDTUBE WELDMENT, LH
1	1								D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8	8	8	350A41-1027-20	SCREW
**3	8	8	8	8	8	8	8	8	23119AG120LE	WASHER
**4	8	8	8	8	8	8	8	8	22541N120	NUT
**5	1	1	1	1	1	1	1	1	AN8C35A	BOLT
**6A	1	1	1	1	1	1	1	1	NAS1149C0832R	WASHER
**7	1	1	1	1	1	1	1	1	MS21083C8	NUT
**8	1	1	1	1	1	1	1	1	D3488-3	BLADE FITTING, LH
**8	1	1	1	1	1	1	1	1	D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1	1	1	D2741	BLADE
10	2	2	2	2	2	2	2	2	AN8C21A	BOLT
11	2	2	2	2	2	2	2	2	NAS1149C0863J	WASHER
12	2	2	2	2	2	2	2	2	MS21083C8	NUT
**14	4	4	4	4	4	4	4	4	AN6C44A	BOLT
**15	8	8	8	8	8	8	8	8	D2745	BUSHING
**16	4	4	4	4	4	4	4	4	MS21043-6	NUT
**17	8	8	8	8	8	8	8	8	D3631-1	WASHER
**18	4	4	4	4	4	4	4	4	ALS4-1032-225	INSERT
**19	4	4	4	4	4	4	4	4	AN3C6A	BOLT
**20A	4	4	4	4	4	4	4	4	NAS1149C0332R	WASHER
**20B	4	4	4	4	4	4	4	4	NAS1515H3L	WASHER

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Item	Qty	-015	-016	-017	-018	-023	-024	-047	Part Number	Description
*30	8	8	8	8					D3492-041	PLUG ASSEMBLY
*31	8	8							D3492-043	PLUG ASSEMBLY
*32	8		8	8					D3492-045	PLUG ASSEMBLY
**43	2	2	2	2					D3493-1	WASHER
*90	1	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A				1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	7	8	D3873-1	BUSHING
94A				1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96								4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS
² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS
³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS
⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

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